

Solid carbide HPC end mill

4 flutes, ULTRA-coated

ORION®



Application

HPC end mill with uneven twist and uneven pitch for universal rough machining and smoothing.

Version

- Solid carbide ultra-fine grain
- Straight shank as per DIN 6535 HA and HB
- ULTRA-coated
- With clearance
- Uneven twist angle 35°/38°
- With edge protection chamfer
- Edge-rounded flutes
- Centre cutting
- Uneven flute pitch

Advantage

- Extremely smooth running
- Reduced oscillation
- Higher feed rates and cutting depths possible
- Ideal for static and dynamic trochoidal milling
- Defined edge rounding for outstanding service life

Application	Steel (N/mm ²)			Stainless steel		Alu		Brass		Bronze		Plas-tics	Graphite G(C)FK	GG(G) GJMW	Titan-alloy	Nickel-alloy	Super-alloy	Hard mat.	
	<700	<1000	<1300	marten.	austen.	short	long	short	long	short	long							<55 HRC	<65 HRC
	230	190	150	120				350		240	280			160		70	70		

Art. No.	16851 213
Cutting material	VHM
Surface	ULTRA
Type	N
Number of cutting edges	4 PCS
Twist angle	35°, 38°
Tool holding device	HB parallel shank
Overall length	Normal
Cutting edge diameter	12 mm
Cutting edge length	26 mm
Clearance length	36 mm
Length	83 mm
Edge protection chamfer length	0.2 mm
Clearance diameter	11.6 mm
Shaft diameter	12 mm
fz steel 1000	0.08 mm
Overall stainless steel suitability	1
fitness not iron total	2
fitness Titan/Nickel/Super total	1

EAN-Code

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